

Date: Friday, 17/08/2007 11:22:00 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE BILLET
<b>Job Number</b> : 34106	
<b>Estimate Number</b> : 10033	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D6101003
<b>This Issue</b> : 17/08/2007 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D6101 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 33792	<b>Material</b> : N/A
<b>Written By</b> : <u>                    </u>	<b>Due Date</b> : 10/09/2007 <b>Qty:</b> 60 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>                    </u>	
<b>Comment</b> : Est. A: 01.05.04 New Issue EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O:

4392

C207108117

a) Description: Alluminum billet

b) 7.875" x 6.250" x 2.00" thick

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Grain direction along 7.875" length

e) Material: 7075-T7351 (QQ-A-250/12)

f) Material certification required

(60)

2.0

D6101003P

7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total: 60.0000 Each(s)  
 7075-T7351 2X6.25X7.875

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

C271431 (60)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Ensure Material certification comply to Dwg D6101

inf 07/09/15

60

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/17  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 17/08/2007 11:22:00 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE BILLET

Job Number: 34106

Part Number: D6101003

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

*ml 07/09/15 60*

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*07/09/17*

Job Completion



*07/09/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

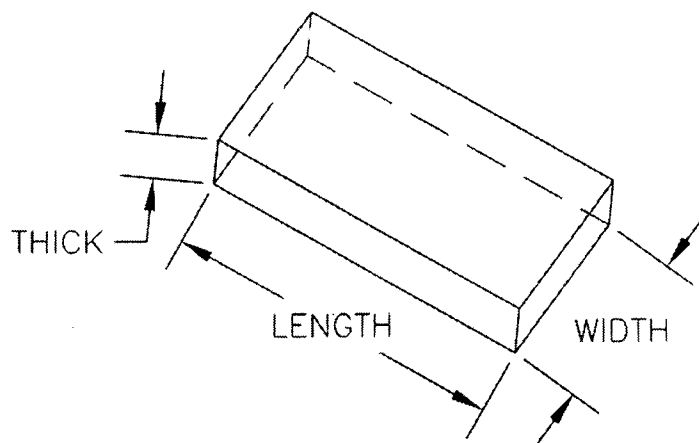
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>JS</i>	DRAWING NO. D6101	Rev. A SHEET 1 OF 1
DATE 01.03.30		TITLE SADDLE BILLET, 7075	SCALE NTS
A	01.03.30	NEW ISSUE	

## SPECIFICATION CONTROL DRAWING

RELEASED  
01.04.23 *CP*



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.030/-0.000), AND GRAIN DIRECTION AS SHOWN.

TOLERANCES ON ALL DIMENSIONS ARE +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	Length	Width	Thick	Grain Direction
D6101-001	7075-T7351 (QQ-A-250/12)	6.000	6.250	2.000	Along 6.000 Length
D6101-003	7075-T7351 (QQ-A-250/12)	7.875	6.250	2.000	Along 7.875 Length
D6101-005	7075-T7351 (QQ-A-250/12)	5.000	8.250	2.500	Along 5.000 Length
D6101-007	7075-T7351 (QQ-A-250/12)	7.750	8.250	2.500	Along 7.750 Length
D6101-009	7075-T7351 (QQ-A-250/12)	8.700	8.250	2.500	Along 8.700 Length
D6101-011	7075-T7351 (QQ-A-250/12)	9.700	8.250	2.500	Along 9.700 Length
D6101-013	7075-T7351 (QQ-A-250/12)	10.100	8.250	2.500	Along 10.10 Length

Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O: 34106

ALCAN  
ROLLED PRODUCTS

## CERTIFIED TEST REPORT

RAVENSWOOD, WV 26184 USA



A M CASTLE & CO  
3400 NO WOLF ROAD  
FRANKLIN PARK IL  
60131



A M CASTLE & CO  
3400 NO WOLF ROAD  
FRANKLIN PARK IL  
60131

A M CASTLE A44806 1512 INCLUSION SERIAL#: 20070504A44806 PAGE 2 OF 2

CUSTOMER PURCHASE ORDER NO. & ITEM <b>01-84320</b>				ALCAN ORDER NO. <b>113-581187</b>	
ALLOY <b>(7075)</b>	CLAD. <b>00</b>	TEMPER <b>T7351</b>	GAUGE <b>2.00000</b>	WIDTH <b>48.500</b>	LENGTH <b>144.500</b>
ITEM ORDERED <b>DIST. AEROSPACE/COMM. SPEC PLATE, SAWED MILL</b>					
CUSTOMER SPECIFICATION <b>AMS-QQ-A-250/12</b>					
PART NUMBER		B/L NUMBER <b>A44800</b>		DATE SHIPPED <b>05/06/07</b>	
WEIGHT SHIPPED <b>2,920</b>		NO. OF PIECES <b>2</b>		GOVT. CONTRACT NO.	

## CERTIFICATION

"ALCAN Rolled Products, hereby certifies that metal shipped under this order has been inspected and found in conformance with the requirements of the applicable specifications as indicated herein. Any warranty is limited to that shown on ALCAN Rolled Products' standard General Terms and Conditions of Sales. Test reports are on file, subject to examination."

## ALCAN ROLLED PRODUCTS

P.O. BOX 68

RAVENSWOOD, WV 26184 USA

LaDonna B. Smith - Quality Manager

LOT NUMBER	TEST DIRECTION	NO. OF TESTS	ULTIMATE STRENGTH K.S.I.		YIELD STRENGTH K.S.I.		ELONGATION %		COND % IACS										
			MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN	MAX									
			ACTUAL CHEMICAL COMPOSITION																
350441 C SI= 0.06 FE= 0.16 CU= 1.42 MN= 0.01 MG= 2.52 CR= 0.19 ZN= 5.42 TI= 0.03 OTHERS-EACH: .05 MAX. OTHERS TOTAL: .15 MAX. AL REMAINDER																			
THIS TEST REPORT SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF THE LABORATORY OR AUTHORIZED QUALITY DELEGATE. <del>THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTRIES ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW.</del>																			
CHEMISTRY BY OES: ARKSPARK																			
CHEMISTRIES REPORTED IN PERCENTAGE BY WEIGHT.																			
WHEN FRACTURE TOUGHNESS TEST REQUIRED, TESTED PER ASTM E399.																			
WHEN TENSILE TEST REQUIRED, TESTED PER ASTM E8; B557.																			
"END OF CERTIFICATION"																			
C H E M C O M P	ALLOY	SILICON		IRON		COPPER		MANGANESE		MAGNESIUM		CHROMIUM		ZINC		TITANIUM		OTHERS	
		MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	MIN.	MAX.	EACH MAX.	TOTAL MAX.
		SEE ACTUAL CHEMICAL COMPOSITION																	
ALUMINUM REMAINDER																			